

Work Order ID 62234

Wednesday, September 22, 2010 3:33:30 PM



Page 1

Item ID: D3720-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 9/22/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 9/29/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

RL

Date: 10-9-23

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3720	Rev A								

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3720 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

6061 - 125

10-9-27

(12)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

10-9-27

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

810609/27

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 9/29/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	C'sink as per dwg D3720								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
150 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

EP 10/09/28 (12)

S. L. L. L. L.

(12)

10-9-09

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 9/22/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 9/29/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

QC3- Inspect Part Finish

0.00

⇒ JLL

10/09/29

x12

✓

Quality Control

Memo

0.00

170



Packaging

Identify as per dwg & Stock Location: 083

0.00

Memo

0.00

Packaging

Cu 10/8/29 (12)

180



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

10/09/30

MF
10-9-29

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, September 22, 2010 3:33:40 PM

Page 1

Work Order ID: 62234



Parent Item: D3720-1



Parent Item Name: Step Spacer


Start Date: 9/22/2010

Required Date: 9/29/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev :A New Issue 08-01-11 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125  6061-T6 .125 Sheet		Purchased	No			100	sf	113.7600	0.085	0.894737	1.1		



BIG-9-27

Location

Loc Qty

Loc Code

MAT21

113.76

113608

96

114352

17.76

114362

W/O:		WORK ORDER CHANGES					
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Dart Aerospace Ltd

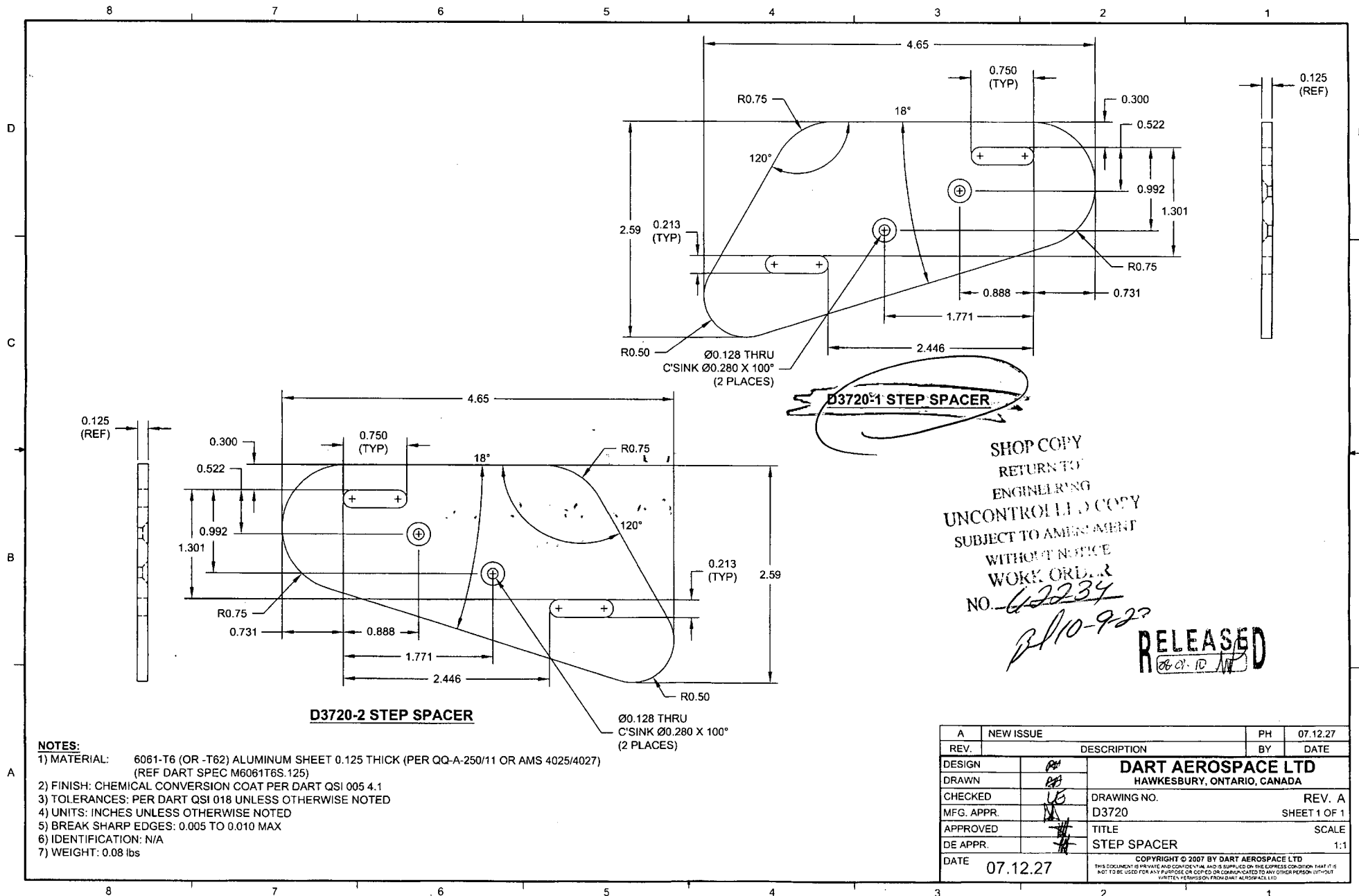
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 62234

3/10-92

RELEASED
66-01-10

A		NEW ISSUE		PH	07.12.27
REV.		DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN					
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.		STEP SPACER			
DATE	07.12.27	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD</small> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

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